

Work Order ID 62164

Monday, September 20, 2010 10:09:45 AM

Page 1

Item ID: D3684-047

Accept

Revision ID:

Item Name: FWD LEG ASS'Y

Start Date: 9/20/2010 Start Qty: 2.00

Required Date: 9/27/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: mt Date: 10-9-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	Rev D

100	Pick Kit	0.00
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Packaging

Memo

0.00

Packaging

110



Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

1-Use anti-seize compound Tectly 502c Class I, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

**Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

EP 10/09/20 (2)

EP 10/09/20 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start
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120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	SB	10/09/21		2			
130 Packaging Packaging	Identify as per dwg & Stock Location: GA W/O 62163 Memo 62170	0.00 0.00	SB	10/09/21		2			
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/09/21
MF
10-9-21

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Picklist Print

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Page 1

Work Order ID: 62164



Parent Item: D3684-047



Parent Item Name: FWD LEG ASS'Y

Start Date: 9/20/2010

Required Date: 9/27/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	86.0000	2	4		9/20/09/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		86							
				112314		8							
				114761		11							
				115392		47			4				
				115594		20							
D3688-1 STUD		Manufactured	No			110	Each	10.0000	1	2		9/20/09/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		10							
				58635		4							
				59668		6			2				
D3689-1 SLEEVE		Manufactured	No			110	Each	13.0000	1	2		9/20/09/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST082		13							
				56335		1							
				58634		12			2				

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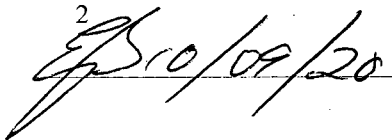









Parent Item Name: FWD LEG ASS'Y

Start Date: 9/20/2010

Required Date: 9/27/2010

Start Qty: 2.00

Required Qty: 2.00

D3691-1	Manufactured	No	110	Each	15.0000	1	2
							
STUD							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	15			
			58631	15			2
D3692-1	Manufactured	No	110	Each	349.0000	4	8
							
SPACER							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	349			8
			51467	349			
D3693-1	Manufactured	No	110	Each	40.0000	1	2
							
Rod End Bearing							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	40			2
			50734	40			
MS21043-3	Purchased	No	110	Each	2,643.000	2	4
							
Nut							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			FG	76			
			103691	76			
			ST301	2567			
			109147	4			
			111383	46			
			112314	2517			4

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Start Date: 9/20/2010

Required Date: 9/27/2010

Start Qty: 2.00

Required Qty: 2.00

NAS509-12C

Purchased

No

110

Each

46.0000

1



2
9/20/09/20

Nuts

Location

Loc Qty

Loc Code

ST280

46

112453

46

NAS509L12C

Purchased

No

110

Each

51.0000

1



2
9/20/09/20

Nuts

Location

Loc Qty

Loc Code

ST280

51

112314

41

112828

10

2

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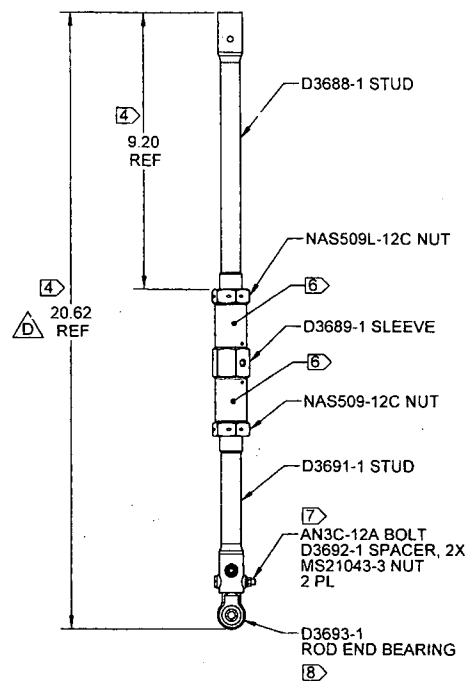
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT

#62164





D3684-047 FWD LEG ASSEMBLY



NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
2010-03-15

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. D
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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